

ASAP - Geneva

Dart Aerospace Ltd.

Date: Friday, 19/01/2007 8:50:52 AM  
User: Linda Lacelle

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	SHIM
<b>Job Number</b> :	30332		
<b>Estimate Number</b> :	12655		
<b>P.O. Number</b> :	N/A	<b>Part Number</b> :	G106103
<b>This Issue</b> :	19/01/2007	<b>S.O. No.</b> :	N/A
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	G10610 REV A
<b>First Issue</b> :	N/A	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	N/A	<b>Drawing Revision</b> :	A
	<b>Type</b> :	<b>Material</b> :	N/A
	SMALL /MED FAB	<b>Due Date</b> :	26/01/2007
<b>Written By</b> :			<b>Qty:</b> 20 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :			
<b>Comment</b> :	Est Rev:A New Issue 07-01-16 JLM		

### Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M2024T3S050	2024-T3 .050 sheet
-----	-------------	--------------------



**Comment:** Qty.: 0.0201 sf(s)/Unit Total: 0.4011 sf(s)  
2024-T3 .050 sheet  
\*\*\*\*\*Grain must Run Along 8.59" Dim \*\*\*\*\*  
Batch: ~~M103210~~ M103210

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



**Comment:** FLOW WATER JET  
1-Cut as per Dwg G106101  
Dwg Rev: A  
Prog Rev: A

2-Deburr if necessary

SAD 02/01/21 (20)

MF. 07-01-23 (20)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/01/21 (20)

4.0	QC8	SECOND CHECK
-----	-----	--------------



**Comment:** SECOND CHECK

07/01/22 (20)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



**Comment:** HAND FINISHING RESOURCE #1  
Chemical Conversion Coat as per QSI 005 4.1

M. G / a.m 07/01/23

(20x)

Date: Friday, 19/01/2007 8:50:52 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHIM

Job Number: 30332

Part Number: G106103

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF 07-01-23

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

10 7/01/23 (20) 07/01/26 (20)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07-01-30

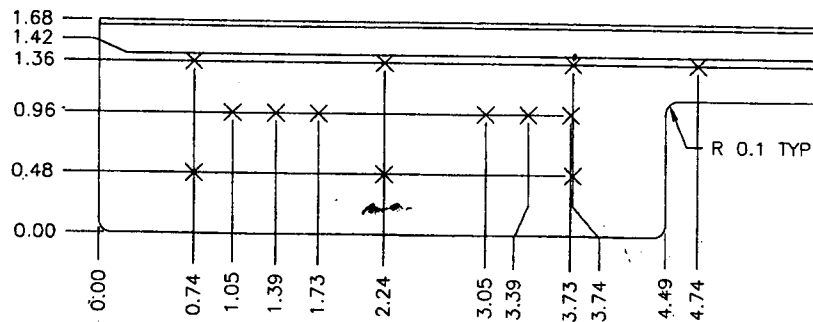
Job Completion



U 07-01-30

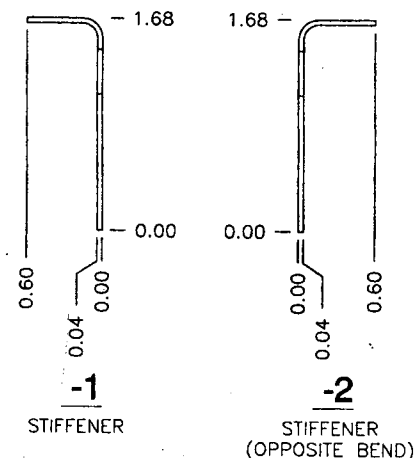
W/O 30332

REVISION			
REV	DESCRIPTION	DATE	APPROV.
A	9.75 WAS 8.98, 9.00 WAS 8.25, ADDED MATERIAL CALLOUT FOR -3	4/8/01	CLB



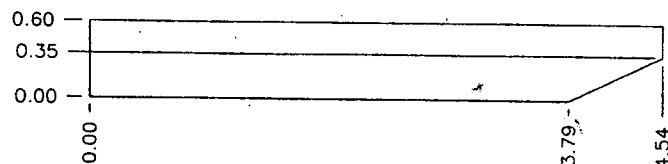
-1  
STIFFENER

-2  
(OPPOSITE BEND)



-1  
STIFFENER

-2  
STIFFENER  
(OPPOSITE BEND)




-3  
SHIM

(0.05)

# NOTES:

UNLESS OTHERWISE NOTED.

- MAT'L:  
 (A) -1 ALUM, 0.04 THICK, 2024-T4 AU4G1.  
 -2 ALUM, 0.04 THICK, 2024-T4 AU4G1.  
 -3 ALUM, 0.05 THICK, 2024-T4 AU4G1.
- INSIDE BEND RADIUS: 3T, 90°±5'.
- FINISH: ETCH, ALODINE PER MIL C5541-1A, PAINT WITH ACRYLIC URETHANE.
- ALL HOLE LOCATIONS ARE RECOMMENDED REFERENCE ONLY. FINAL LOCATIONS TO BE DETERMINED AT INSTALLATION. MATCH DRILL PARTS AT ASSEMBLY.

BREAK ALL EDGES UNLESS OTHERWISE SPECIFIED DIMENSION ARE IN INCHES DIMENSIONAL TOLERANCES 3 DECIMALS ± 2 DECIMALS ±.020 1 DECIMAL ±.050 ANGULAR ± 1°	DRAWN	DT	DATE	 <b>GENEVA AVIATION</b> 10108 - 32nd Ave W Everett, WA 98204 (425)353-7400 FAX(425)347-7100
	CHECK		DATE	
	DESIGN		DATE	
	APPROVAL	DCF	DATE	
THIS DRAWING INCLUDES INFORMATION PROPRIETARY TO GENEVA AVIATION AND SHALL NOT BE USED OR DUPLICATED BY ANYONE WITHOUT THE WRITTEN PERMISSION OF GENEVA AVIATION INC.				TITLE <b>REAR SHOULDER HARNESS          INSTALLATION MODIFICATION</b>
				DWG NO. <b>G10610</b> REV. <b>A</b>
				PRO NO. <b>GA159</b> SIZE <b>B</b> SCALE <b>1/1</b> SHT. <b>1 OF 2</b>

DART AEROSPACE LTD		Work Order:	3033-2
Description:		Part Number:	6106103
Inspection Dwg:	Rev:	Page 1 of 1	

## FIRST ARTICLE INSPECTION CHECKLIST

## Prototype

[illegible]

Measured by: <b>SAD</b>	Audited by: <b><del>NA</del></b>	Prototype Approval: <b>N/A</b>
Date: <b>07/01/21</b>	Date: <b>07/01/22</b>	Date: <b>N/A</b>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

SHIP TO: TRENTWOOD WORKS PO BOX 99215 SPOKANE, WA 99215					
SOLD TO: Kaiser Aluminum Trentwood Works PO BOX 99215 SPOKANE, WA 99215					
CUSTOMER PO NUMBER: N18187		WORK PACKAGE:		CUSTOMER PART NUMBER:	
Kaiser Order No: 1033832		LINE ITEM: 1		SHIP DATE: 24-MAR-2008	
WEIGHT SHIPPED: 7895 LB		QUANTITY: 223 PCS EST.		M/L NUMBER: 207855	
ALLOY: 2024		CLAD: CLAD		TEMPER: T3	
GAUGE: 0.0500 IN		WIDTH: 48.000 IN		LENGTH: 144.000 IN	

# KAISER ALUMINUM

Trentwood Works - Spokane, WA 99215  
Phone: (800) 367-2586

## CERTIFIED TEST REPORT

Serial Number  
4062914

### Certified Specifications

AMS 4041/RevP  
BATS 2505/RevNC

AMS-QQ-A-2805/RevA  
DMS 2174/RevB

ASTM B 209/Rev04

Test Code: 4019

Lot: 350042A8 Cast 318

Drop 16

Ingot 2

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T3	LT / 2 (Min:Max)	63.9 : 64.7 (441 : 446)	44.8 : 45.8 (309 : 316)	15.2 : 15.8

MRS Deflection: 0.017 IN

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.09	0.24	4.87	0.59	1.40	0.01	0.13	0.02	0.01	0.01	0.04

### ALLOY LIMITS

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
2024 MIN	0.00	0.00	3.80	0.30	1.20	0.00	0.00	0.00	0.00	0.00	EACH	0.05
MAX	0.50	0.50	4.90	0.90	1.80	0.10	0.25	0.15	0.05	0.05	TOT	0.15
LINER MIN	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	EACH	0.03
MAX	0.25	0.40	0.05	0.05	0.05	0.00	0.05	0.05	0.05	0.00	TOT	0.00

Aluminum Remains

### TEST NOTES

MATERIAL MEETS MINIMUM RESIDUAL STRESS (MRS) CHEMICAL  
MILLING QUALITY (CMQ) REQUIREMENTS.



G10610-3 B30332

Page 1 of 2